

Date: Tuesday, 16/09/2008 3:28:21 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUNNEL BOTTOM PANEL
Job Number : 42038	
Estimate Number : 13026	
P.O. Number :	Part Number : D3649041
This Issue : 16/09/2008 S.O. No. :	Drawing Number : D3649 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 42022	Material :
Written By :	Due Date : 30/09/2008 Qty : 5 Um : Each
Checked & Approved By : <u>JUL 08.9.16</u>	
Comment : Est Rev:A New Issue 07-09-26 EC verified by: DD Est Rev:B ECN 1113P 08-01-22 DD verified by: EC Est Rev:C Ecn1162 08-04-02 DD verified by:EC	

Additional Product



Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



MAT NOT PULLED
CUT & MAT



Comment: Qty.: 6.3725 sf(s)/Unit Total : 31.8623 sf(s)
 304/316 SS sheet 26 ga (0.018" thick)
 Batch: 108165 *HB 8-9-18 26*

POSITIVE RECALL

EFFECTIVE 8.9.16 AUTH U

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

RELEASED U DATE 8/9/26**Comment:** FLOW WATER JET

1-Cut as per Dwg D3649

Dwg Rev: BProg Rev: B*HB 8-9-18 26*2-Deburr if necessary *HB 8-9-18 26*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------

*HB 8-9-18 26***Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

S color *(26)*
(26)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------

**Comment:** NC BRAKE

Form as per Dwg D3649

HB 08/09/29 *(6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/09/2008 3:28:21 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUNNEL BOTTOM PANEL

Job Number: 42038

Part Number: D3649041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/02/29 (6)

7.0

MS210603K

Nut Plate



Comment: Qty.: 22.0000 Each(s)/Unit Total: 110.0000 Each(s)

Nut Plate

M109371

8.0

MS210623K

Nut Plate



Comment: Qty.: 22.0000 Each(s)/Unit Total: 110.0000 Each(s)

Nut Plate

M108669 38X

9.0

MS20427M33

Rivet



Comment: Qty.: 88.0000 Each(s)/Unit Total: 440.0000 Each(s)

Rivet

M109371

508/10/01 (6)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Form dimple for MS20427M3 rivet per dwg D3649

*****ensure dimples are on the proper side*****

2-Assemble nutplates as per dwg D3649

508/10/02 (6)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/02 (6)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: GA

508/10/02 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/09/2008 3:28:21 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUNNEL BOTTOM PANEL

Job Number: 42038

Part Number: D3649041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/03 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



LN 08.10.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42038
Description: Tunnel Bottom Panel		Part Number: D3649-1
Inspection Dwg: D3649	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☐

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.102	X			
Ø0.196	+0.005/-0.001	.200	X			
Ø0.250	+0.005/-0.001	.254	X			
0.400	+/-0.010	.403	X			
0.385	+/-0.010	.387	X			
0.250	+/-0.010	.252	X			
44.57	+/-0.030	44.57	X			
11.70	+/-0.030	11.70	X			
3.370	+/-0.030	3.370	X			
13.76	+/-0.030	13.76	X			
4.300	+/-0.010	4.300	X			
10.11	+/-0.030	10.11	X			
12.90	+/-0.030	12.90	X			
16.61	+/-0.030	16.61	X			
15.80	+/-0.030	15.80	X			
3.950	+/-0.010	3.950	X			
0.42	+/-0.030	.421	X			
0.41	+/-0.030	.408	X			
0.85	+/-0.030	.858	X			
19.64	+/-0.030	19.40	X			
0.54	+/-0.030	.54	X			
1.400	+/-0.010	1.395	X			
2.63	+/-0.030	2.626	X			
2.93	+/-0.030	2.921	X			
1.49	+/-0.030	1.497	X			
5.98	+/-0.030	5.977	X			
0.54	+/-0.030	.54	X			
2.20	+/-0.030	2.196	X			
2.75	+/-0.030	2.74	X			
2.48	+/-0.030	2.470	X			

DART AEROSPACE LTD		Work Order: 42038
Description: Tunnel Bottom Panel		Part Number: D3649-1
Inspection Dwg: D3649	Rev: B	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.16	+/-0.030	1.164	X			
3.38	+/-0.030	3.373	X			
2.00	+/-0.030	1.997	X			
0.90	+/-0.030	.894	X			
16.64	+/-0.030	16.60	X			
0.48	+/-0.030	.499	X			
13.80	+/-0.030	13.80	X			
0.46	+/-0.030	.479	X			
11.76	+/-0.030	11.75	X			
1.23	+/-0.030	1.226	X			
0.88	+/-0.030	.901	X			
18.46	+/-0.030	18.46	X			
5.23	+/-0.030	5.233	X			
1.932	+/-0.010	1.940	X			
1.943	+/-0.010	1.940	X			
5.02	+/-0.030	5.018	X			
1.820	+/-0.010	1.818	X			
0.70	+/-0.030	.709	X			
2.100	+/-0.010	2.101	X			
2.33	+/-0.030	2.332	X			
0.94	+/-0.030	.938	X			
3.30	+/-0.030	3.293	X			
1.900	+/-0.010	1.894	X			
0.61	+/-0.030	.607	X			

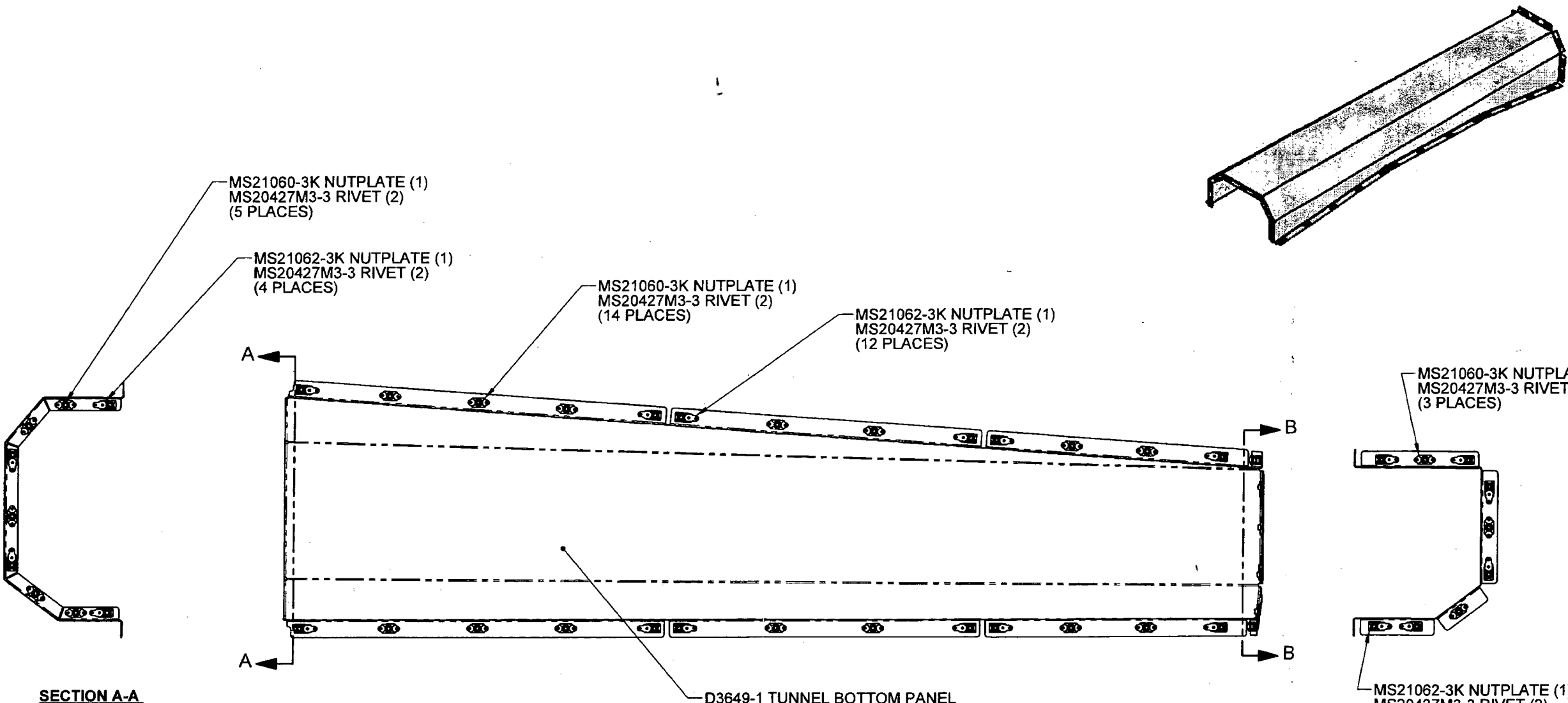
Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 8-9-2020	Date: 08/09/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	P/O D3649-041 KJ/DD	

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



SECTION A-A

SECTION B-B

D3649-041 BOTTOM PANEL ASSEMBLY

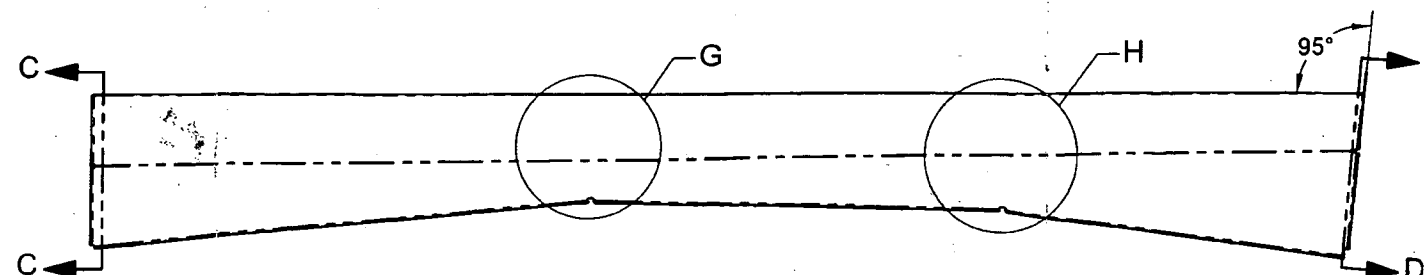
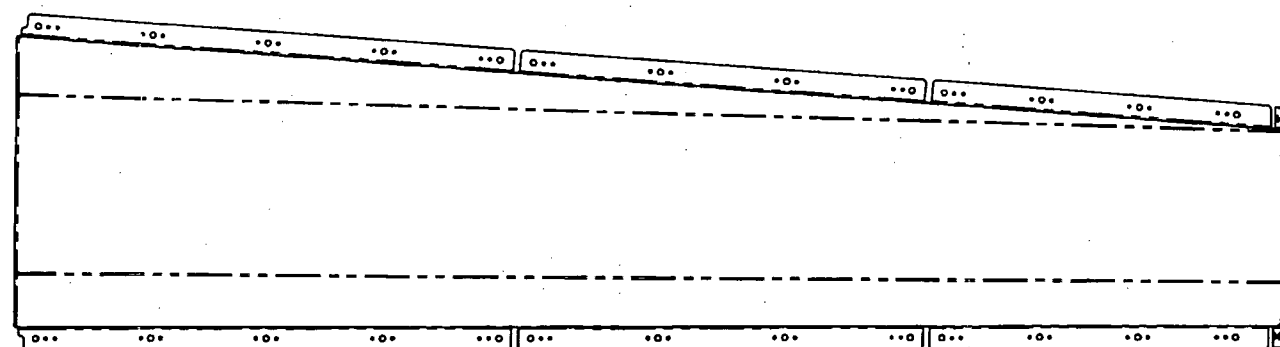
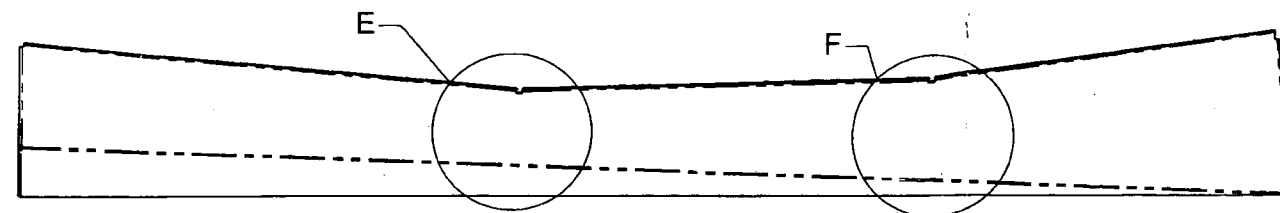
PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3649-041	TUNNEL BOTTOM PANEL ASSY.
1	D3649-1	TUNNEL BOTTOM PANEL
88	MS20427M3-3	RIVET
22	MS21060-3K	NUTPLATE
22	MS21062-3K	NUTPLATE


REV.	B	PAGE 3: MS20427M3 WAS MS20427M-3	RF	08.01.07
	A	NEW ISSUE	RF	07.11.07
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	IE	DRAWING NO.	REV. B	
MFG. APPR.	RF	D3649	SHEET 1 OF 3	
APPROVED	RF	TITLE	SCALE	
DE APPR.	RF	BOTTOM PANEL ASSEMBLY		
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD.		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

RELEASED
08.03.28

TOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42038



D3649-1 TUNNEL BOTTOM PANEL
(MAKE FROM D3649-1F)

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3649	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BOTTOM PANEL ASSEMBLY	1:6
DATE 08.01.07		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
08-03-27

SCALE: SHOP COPY
1:6 RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42038

